

Date: Tuesday, 7/11/2006 1:05:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27867A -1
Estimate Number : 10452
P.O. Number : N/A
This Issue : 7/11/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 27593A
Written By : SEE COMMENT BELOW
Checked & Approved By : J.F. 06.07.11
Comment : Est:A 04.04.19 New issue KJ/JLM
Drawing Name : SUPPORT
Part Number : D32781
Drawing Number : D3278 REV. B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 7/30/2006 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.4572 f(s)/Unit Total: 18.2868 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
(M6061T6B1.000x02.000)

Batch: M101000/17PCS M18745/2PCS
M15949/21PCS J.F. 06/07/11 42

2.0 SHEAR SHEAR



Comment: SHEAR
Cut blank: 2.00" x 1.00" x 2.550" long

J.F. 06/07/11 42

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA405 and Dwg D3278
2- Deburr and Tumble
Identify as D3278-1

J.F. 06/07/11 42

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/07/12 42

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06.07.13. 30

PTO Split

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-13	4	WRO split. Parts under tol. waiting for response. Qty 10	J	06-07-13	10		J 06-07-13

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/12	3	1 piece that is too thin Not set well is the Vise. 1 piece that the holes are .100" off. Didn't take the origine at the right place.	J 06/07/12	2 parts scrap. destroy. No replace.	J.F. 06/07/12	J 06-07-13	J 06-07-13	J 06-07-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.F. 06/07/17

(30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am 06-07-24

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

(10/07/05) (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51418

LB 06-25-07

(30)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/31

(30)

Job Completion



KJ 06.07.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27867A
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099"				
0.359	+/-0.005	.360"				
Ø.609	+/-0.010	.615"				
0.250	+/-0.010	.251"				
1.480	+/-0.005	1.485"				
R0.125	+/-0.010	R.125"				
0.119	+0.005/-0.004	0.119"				
2.439	+/-0.010	2.439"				
1.980	+/-0.010	1.982"				
R0.130	+/-0.010	R0.130"				
Ø0.257	+0.005/-0.000	Ø.258"				
R0.375	+/-0.010	R.375"				
0.875	+/-0.010	0.876"				
0.500	+/-0.010	.500"				
R0.400	+/-0.010	R0.400"				
1.720	+/-0.010	1.722"				
R0.125	+/-0.010	R.125"				
0.125	+/-0.010	.127"				

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 06/07/12	Date: 06.07.12	Date:	N/A

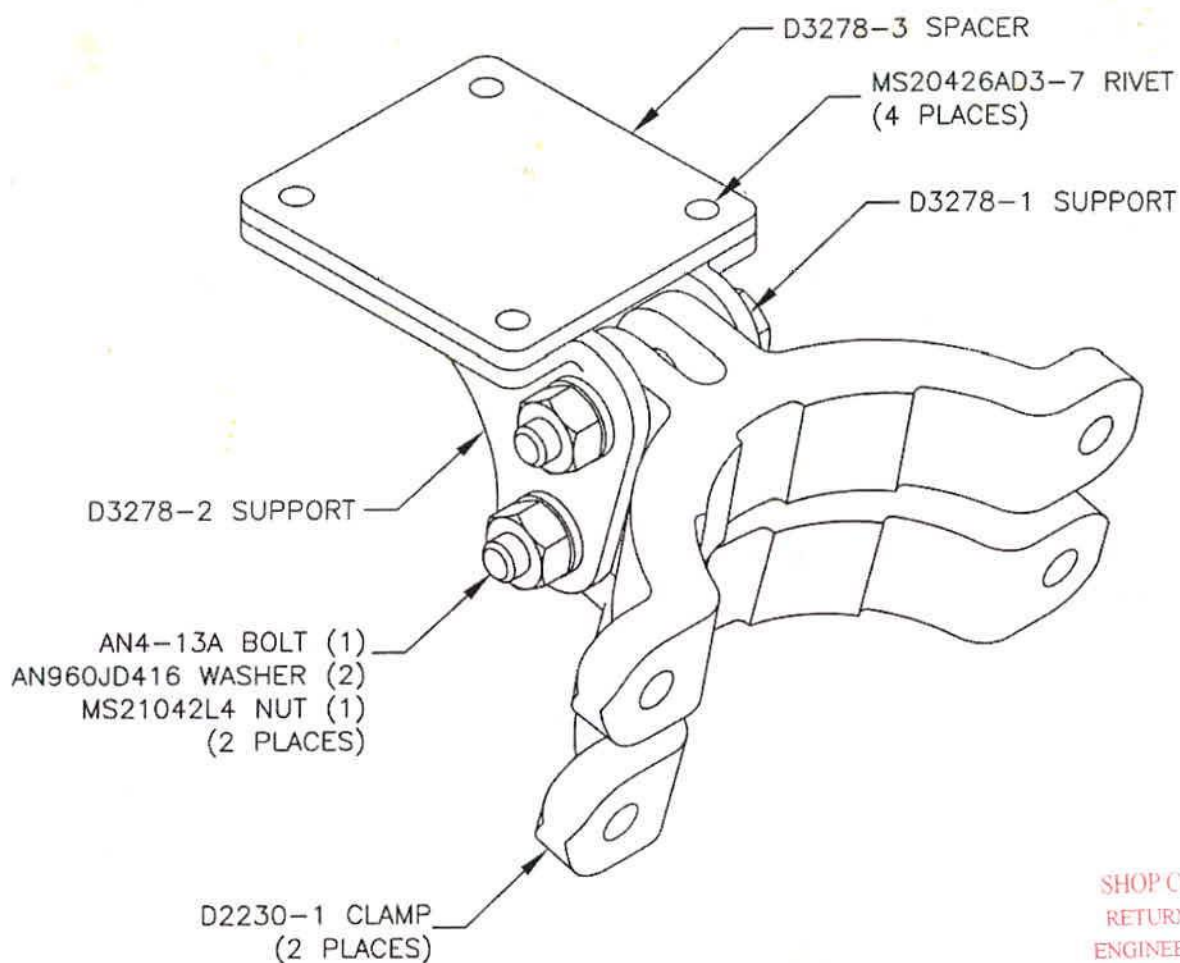
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31			TITLE SUPPORT ASSEMBLY SCALE NTS		
A	04.03.03		NEW ISSUE		
B	05.03.31		CHANGE DIM/TOL TO ENSURE FIT		

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



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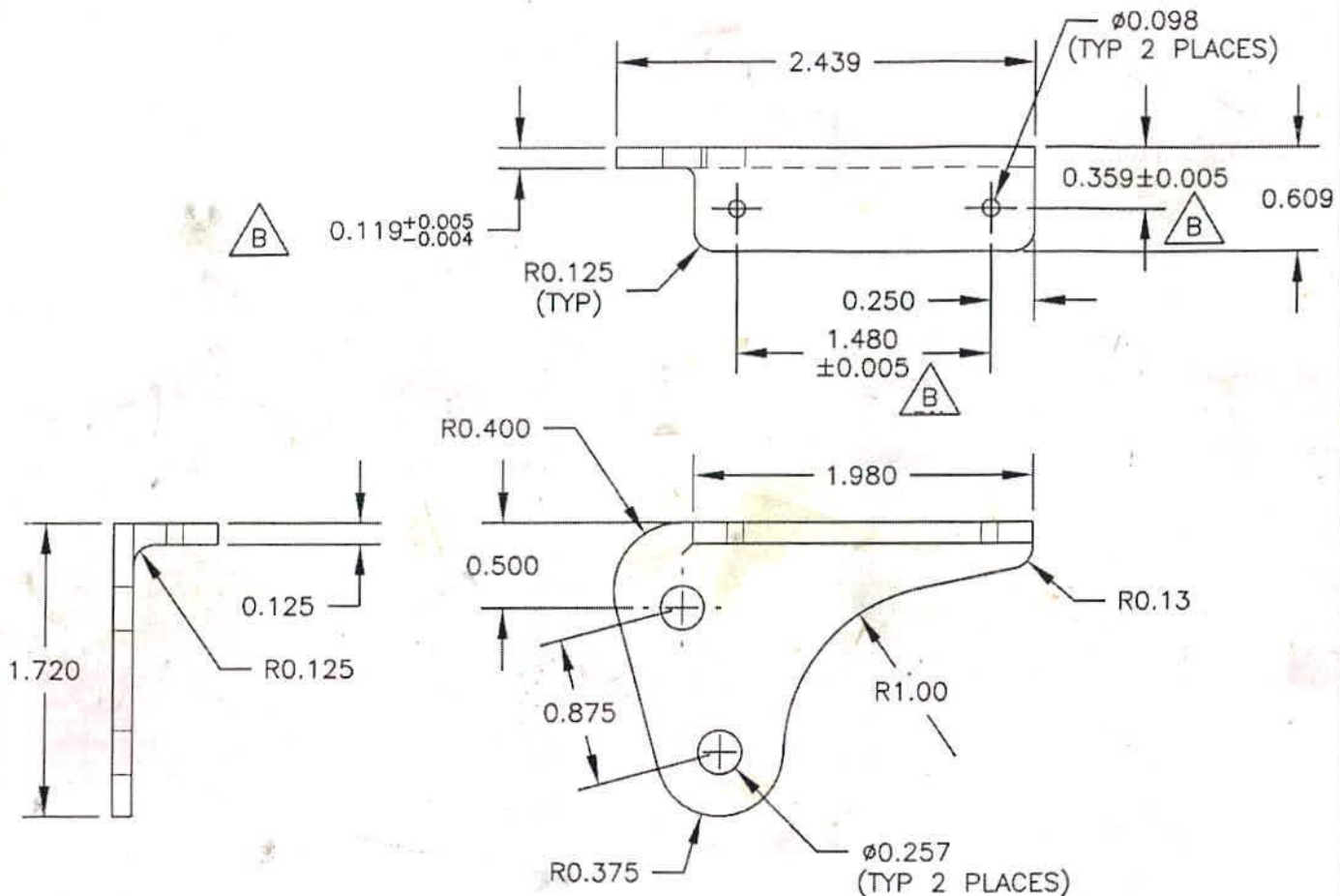
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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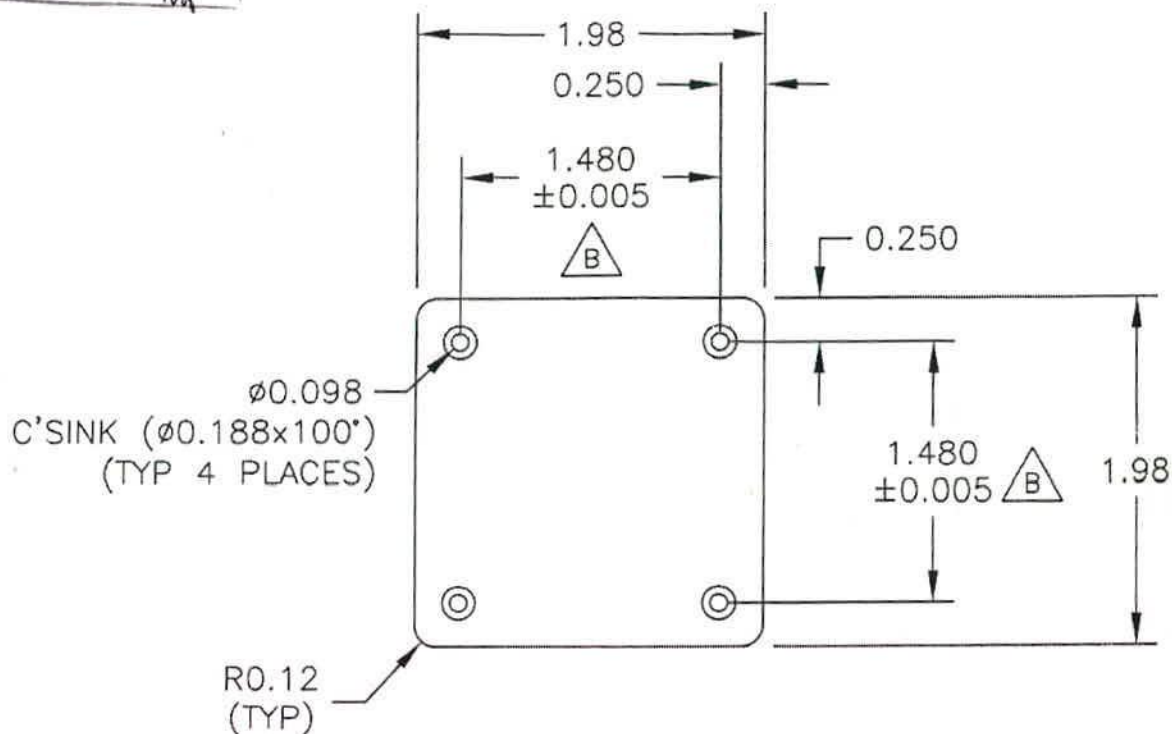
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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